

Date: Thursday, 31/07/2008 1:38:39 PM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 40862  
Estimate Number : 10426  
P.O. Number :  
This Issue : 31/07/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 31/07/2008 Type : MACHINED PARTS  
Previous Run : 40189  
Written By :  
Checked & Approved By : JLD 08801  
Comment : Est: D 04.11.26 Revised Steps 7 KJ/JLM

Drawing Name : TUBE ASSEMBLY  
Part Number : D3304044  
Drawing Number : D3304 REV. B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 08/08/2008

Qty: split 2 / 6 Um: Each

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |                |                             |
|-----|----------------|-----------------------------|
| 1.0 | M304TR0875W065 | 304 round tube .875 x .065w |
|-----|----------------|-----------------------------|



Comment: Qty.: 1.9469 f(s)/Unit Total : 11.6815 f(s)

Material: AISI 304/316 SS tubing 0.875" x 0.065" wall

(M304TR0.875W.065)

Batch: M108232x6

J.F. 08/08/05

|     |          |          |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

1- Cut blank: 22.00" as per Dwg D3304

J.F. 08/08/05 (6)

|     |             |                    |
|-----|-------------|--------------------|
| 3.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: COVENTIONAL LATHE

1- Cut blank: 22.00" as per Dwg D3304

2- Turn as per Dwg D3304

3- Deburr

J.F. 08/08/05 (5)

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/05 (5)

|     |     |              |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.F. 08-06-06 (5)

Date: Thursday, 31/07/2008 1:38:40 PM  
User: Julie Lecoq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40862

Part Number: D3304044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Drill as per Dwg D3304 using drill Jig D3304-T1
- 2- Form as per Dwg D3304
- 3- Cut tube to length as per Dwg D3304
- 4- Check with DT8657 JIG
- 4- Deburr

FF 08/08/25 (5)

SAO 08/08/26 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 08/08/27 (45)

8.0

D33048

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1   | D3304-8     | Bracket     | B2557 |

Batch

B2557

SP 08-08-26 (2x)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

SP 08-08-26 (2x)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-08-28 (2)

11.0

POWDER COATING

POWDER COATING



M106442



(2x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15  
320°F  
10:45

M-F 08/08/28



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40862

Part Number: D3304044

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-28

(2)

13.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIP PIN

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 1   | BLBS-0016   | Pip Pin     |

Batch

103178

SAN 08/08/28

(2)

14.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Loop Sleeve

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2   | CBL-460     | Loop Sleeve |

Batch

M107234

SAN 08/08/28

(2)

15.0

CBL1240

Cable



Comment: Qty.: 1.0416 f(s)/Unit Total : 6.2496 f(s)

Cable

Pick:

| Qty   | Part Number | Description |
|-------|-------------|-------------|
| 12.5" | CBL-1240    | Cable       |

Batch

M103927

SAN 08/08/28

(2)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

Identify as D3304-044

SAN 08/08/28

(2)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/08/28

(2)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40862

Part Number: D3304044

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 188

JS 08/08/28 (2)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) 08/08/29

Job Completion



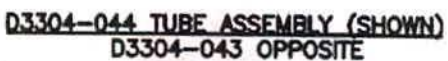
JS 08.08.29





**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

|                    |                    |                                   |                    |  |
|--------------------|--------------------|-----------------------------------|--------------------|--|
| DESIGN             | DRAWN BY           |                                   | DART AEROSPACE LTD |  |
| RF                 | RF                 | HAMKESBURY, ONTARIO, CANADA       |                    |  |
| CHECKED            | APPROVED           | DRAWING NO.                       | REV. B             |  |
| <i>[Signature]</i> | <i>[Signature]</i> | D3304                             | SHEET 1 OF 4       |  |
| DATE               | TITLE              |                                   | SCALE              |  |
| 05.07.15           | TUBE ASSEMBLY      |                                   | 1:6                |  |
| A                  | 04.08.18           | NEW ISSUE                         |                    |  |
| B                  | 05.07.15           | UPDATE DIMENSIONS; ADD D3304-7/-8 |                    |  |



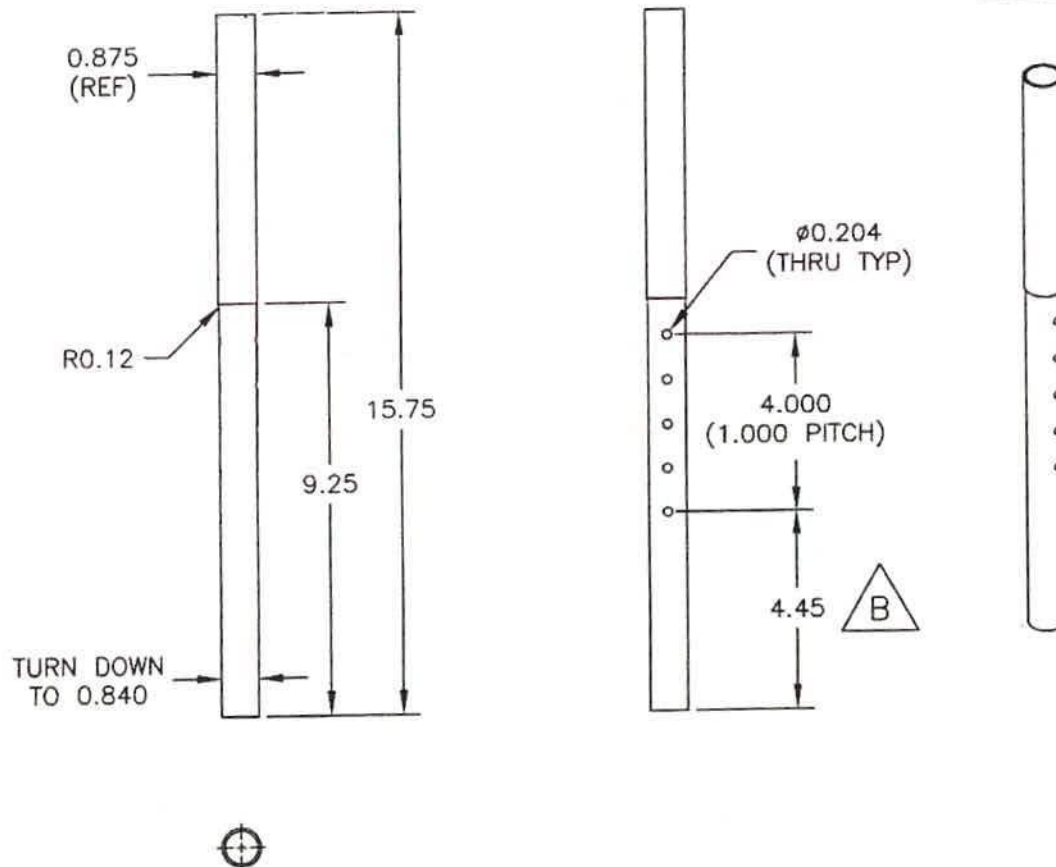
D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GRAY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED  
25-8-11

**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3304                              | REV. B<br>SHEET 2 OF 4 |
| DATE<br>05.07.15              | TITLE<br>TUBE ASSEMBLY         |   | SCALE<br>1:4           |

RELEASED  
05-08-11 *[Signature]***D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

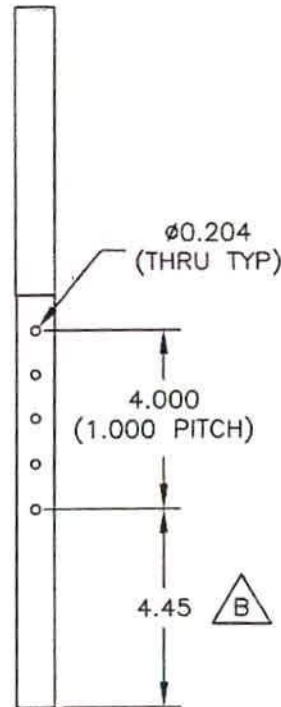
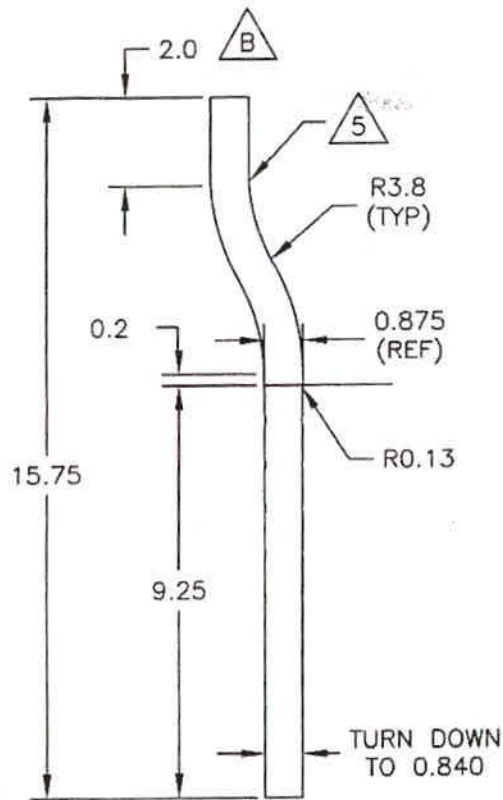
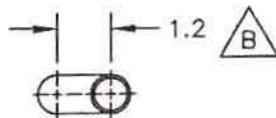
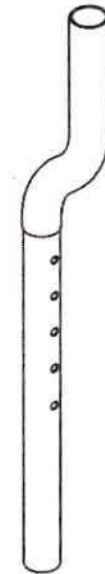
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3304                              | REV. B<br>SHEET 3 OF 4 |
| DATE<br>05.07.15              |                                | TITLE<br>TUBE ASSEMBLY                            | SCALE<br>1:4           |

**RELEASED**  
05-08-11 *[Signature]***D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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